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(54) Motor structure

(57) The motor structure, which has a laminated structure of plural plates 1 and also has a stator pole assembly 10 formed with a component mounting portion, comprises a synthetic resin layer 6 which encloses and covers the plural plates 1 while holding the plates in a closely contacted state, overhang portions (8, 9) integral with the synthetic resin layer 6 and which serve to not only hold but also position motor components, and

an insulating film 7 which covers portions not coated with the synthetic resin. While the synthetic resin layer is formed on the surface of the lamination stack, pressure is applied to the laminated plates as constituents of the stator pole assembly from both upper and lower surfaces of the laminate. This application of pressure is performed using plate pressing projections formed in the mold.

Fig. 1

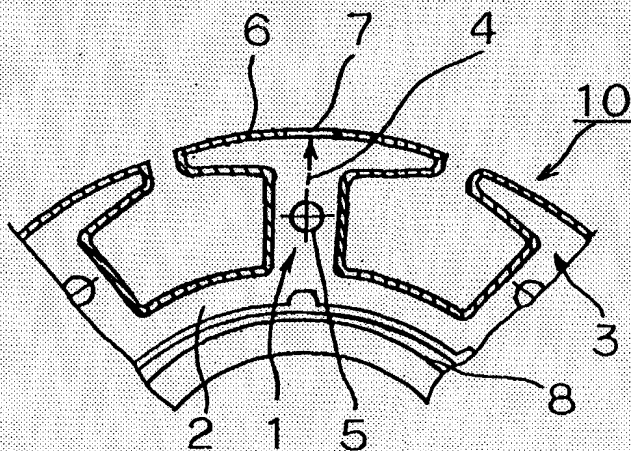
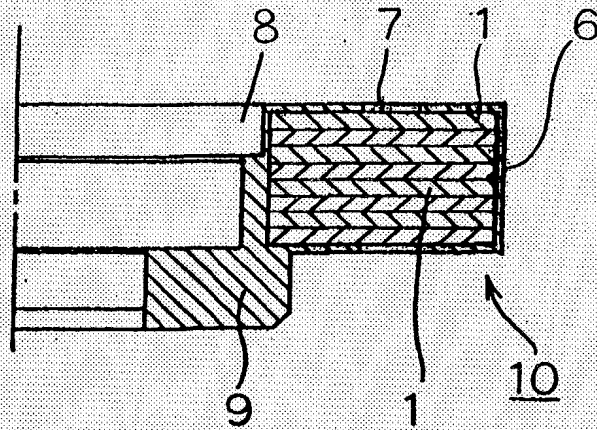


Fig. 2



Description

The present invention relates to a motor structure and a method for manufacturing the same. Particularly, the invention is concerned with a motor structure and a method for manufacturing the same which motor structure and method permit easy insulation of stator poles formed by lamination of soft magnetic plates and easy mounting of components to the stator poles.

Small-sized synchronous motors and stepping motors are used as drive sources of various electronic devices such as floppy disk drives which are peripheral devices of personal computers. As an example of these motors there is known an inner rotor type motor in which a cylindrical rotor comprising poles of permanent magnets is disposed rotatably, and magnetic poles of a stator for generating a rotating magnetic field and thereby imparting a driving force to the rotor are disposed around the rotor in a face-to-face relation to the rotor. The stator poles are fixed to a substrate constituted by an insulated metal plate, while the rotor is supported by two bearings which are fixed respectively to the substrate and the stator poles. Onto the substrate are further fixed an electronic circuit for driving the motor, as well as components such as a position detecting coil for detecting the position of the rotor.

There also is known an outer rotor type motor in which a plurality of magnetic poles are projected radially from an annular yoke member and stator coils are wound round those magnetic poles to constitute stator poles, which stator poles are fixed to a substrate, while a shallow dish-like, or tray-like, rotary disk is disposed rotatably around the stator poles, and permanent magnets disposed inside the edge of the rotary disk are made face to face with the front ends of the stator poles.

According to the prior art, in fabricating the stator poles, no matter which type of motor may be concerned, a plurality of plates formed by pressing from a soft iron plates are stacked together to constitute a lamination stack, then for ensuring insulation between the lamination stack and a coil wound round the stack, an insulator is formed separately using an insulating material such as resin for example and is inserted into the coil winding portion of the lamination stack, or an insulating paint is sprayed directly to the lamination stack to form a thin insulating film on the whole surface of the lamination stack, or the lamination stack is subjected to a chemical treatment to form an insulating film on the surface thereof.

As mentioned above, the conventional assembling method involving separately forming an insulator for the lamination stack, inserting it between magnetic poles and winding a coil thereon, is expensive because of separate formation of the insulator and requires additional number of steps for assembling the insulator.

In the above formation of the insulating film by spray coating, it is impossible to form an insulating film having a uniform thickness throughout the whole surface of the

lamination stack. Particularly, corners and edges are apt to be insufficient in thickness, which may cause dielectric breakdown during use of the motor. Further, in the recent assembling work for a small-sized motor, there is no space for clamping the whole of a pressed plate with pressure using eyelet or the like, with no clamping pressure exerted on the front-end peripheral edge of a stator pole tooth 100, as shown in Figs. 6 and 7. Consequently, there occurs a gap between adjacent laminated plates of the assembled motor, and the plates are rusted in their interiors when used over a long years. Besides, when the stator is excited or the rotor is rotated, the plates vibrate and generate noise. There is an additional inconvenience such that bearing parts and other motor constituting parts must be mounted one by one to the substrate at the time of assembly. In Figs. 6 and 7, the numeral 101 denotes a lamination stack which represents the whole of a stator pole, numeral 102 denotes a yoke portion, numeral 103 denotes a caulking portion for clamping plates 104, and numeral 105 denotes a coating surface which coats the lamination stack 101 in the spray method.

The present invention intends to eliminate the above-mentioned inconveniences of the prior art and it is an object of the invention to provide a novel motor structure and method for manufacturing the same which, when laminating plates as constituents of a lamination stack, can clamp the plates hermetically under pressure and can mount components of the motor to the lamination stack before mounting the motor to a substrate or the like.

According to the present invention, in order to achieve the above-mentioned object, there is provided a motor structure having a laminated structure of plural plates and also having a stator pole assembly formed with a component mounting portion, the motor structure comprising a synthetic resin layer which encloses and coats the plural plates in a closely contacted state of the plates, an overhang portion integral with the synthetic resin layer and which serves to not only hold but also position motor components, and an insulating film which covers a portion not coated with the synthetic resin layer. There also is provided a method for manufacturing a motor structure having a laminated structure of plural plates and a stator pole assembly formed with a component mounting portion, characterized in that a synthetic resin layer is formed on the surface of a lamination stack under the application of pressure from both upper and lower surfaces of the laminated plates which constitute the stator pole assembly.

In the accompanying drawings:

Fig. 1 is a partial front view of a motor's stator pole of this invention;

Fig. 2 is a partial sectional view of a motor's stator pole of this invention;

Fig. 3 is a partial front view of an exposed position adhered with an insulating film;

Fig. 4 is a partial sectional view of an exposed position adhered with an insulating film;

Fig. 5 is a sectional view of assembled motor structure applied this invention;

Fig. 6 is a partial front view of prior art; and

Fig. 7 is a partial sectional view of prior art as seen along line A-A of Fig. 6.

An embodiment of the present invention will now be described in detail with reference to the accompanying drawings. Figs. 1 and 2 are a partial front view and a partial sectional view, respectively, showing a stator pole used in a motor structure embodying the present invention. In these figures, the numeral 1 denotes a plate as a constituent of the stator pole. The plate 1, which is a soft magnetic plate, has an annular yoke portion 2, stator pole portions 3 projecting in a plural number radially outwards from the yoke portion 2, and stator pole teeth 4 formed respectively at the tips of the stator pole portions 3. Plural such plates 1 are laminated together and are caulked at a nearly central portion 5 of each stator pole portion 3. In this state, gaps are formed between stator pole teeth 4, 4 and also between yoke portions 2, 2 of adjacent laminated plates because the tip portions of the stator pole teeth 4 and the yoke portions 2 are not vertically pressed. This problem will be solved if these portions are each formed with a caulking portion as is the case with the stator pole portion 4. However, there is no space for the provision of such fixing means. It also may be one solution to spot-weld the whole of the plates in the thickness direction. However, this method is inconvenient because there will occur an eddy current loss.

In this embodiment, in view of the above-mentioned points, a mold is provided so that a lamination stack constituted by laminating the plates 1 is coated with a synthetic resin material. Projections for pressing the stator pole teeth 4 and the yoke portions 2 of the laminated plates from both upper and lower surfaces are formed beforehand within the mold. The lamination stack is loaded into the mold and the synthetic resin is poured into the mold to form a thin synthetic resin layer 6 on the surfaces of yoke portions 2, stator pole portions 3 and the stator pole teeth 4. Further, spaces for forming portions to fix such components as bearings are formed beforehand in the mold. Therefore, a stator pole assembly after the molding is provided with the said portions, namely overhang portions for not only holding but also positioning motor components. In this embodiment, as shown in Fig. 2, there are formed a circular groove 8 for loose fitting therein of a rotor hub as will be described later and a projection 9 for positioning a stator pole assembly 10 with respect to a substrate.

In this embodiment, since the stator pole teeth 4 and the yoke portions 2 are pressed from both upper and lower surfaces by means of projections during molding and in this state the synthetic resin is poured into the mold, the plates when taken out from the mold are in a

mutually closely contacted state. But there appear exposed portions 7 is not coated with the synthetic resin. Also at the portions which have been in contact with the inner wall of the mold there appear exposed portions 7 and caulking portions 5 not coated with the synthetic resin.

Further, there sometimes appear surface portions partially not coated with the synthetic resin when the resin does not spread uniformly (short mold), for example, when the resin flowing condition changes during molding or when there occurs a positional deviation upon loading of the lamination stack into the mold.

In this embodiment, as shown in Figs. 3 and 4, the exposed portions 7 and the caulking portions 5 not coated with the synthetic resin are coated with an insulating film 7' of a synthetic resin or the like by electrode position coating or by spray coating. More specifically, for example, the whole of the stator pole assembly 10 after taken out from the mold is put into a coating solution tank and is electrically charged negatively, then fine particles of a coating material, which is a positively charged insulating material, are adsorbed on the exposed portions 7 and caulking portions 5 not coated with the synthetic resin. For example, after the stator pole assembly 10 has been charged negatively, if fine particles of the positively charged insulating material as the coating material are sprayed as fine bubbles toward the stator pole assembly 10, the bubbles of the coating material will be concentrated and adsorbed on the exposed portions 7. Upon subsequent drying of the coating material thus applied, all the exposed portions on the surface of the stator pole assembly are covered with the insulating film 7' formed of the coating material.

Fig. 5 is a sectional view of the motor structure using the stator pole assembly to which the present invention was applied. The motor is assembled by fitting the projection 9 into a positioning hole 12 formed in a substrate 11, the projection 9 projecting below the stator pole assembly 10 with a stator coil 13 attached thereto, then fixing the stator pole assembly 10 onto the substrate 11 with use of a fixing means (not shown), thereafter fitting bearings 15 and 16 on a support shaft 14 erected on the substrate 11, and further fitting a rotor 17 on the outer races of the bearings 15 and 16. In this motor, a hub 18 which holds the bearings of the rotor 17 is loosely fitted in a non-contact manner into the groove 8 formed inside the stator pole assembly 10. A terminal 19 connected with the stator coil 13 is attached through the projection 9.

Although the present invention has been described above by way of an embodiment thereof, various modifications may be made within the scope of the gist of the present invention. For example, there may be adopted a method in which the stator pole portion 3 is loaded into the mold so that the whole of the outer peripheral surface of the stator pole portion 3 is in contact with the inner wall of the mold and in which the outer peripheral surface of the stator pole portion 3 not coated with the